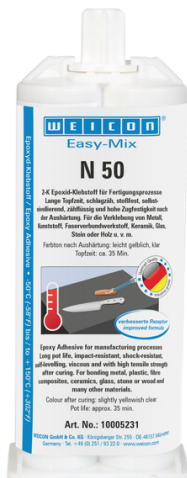


# Easy-Mix N 50



**strong adhesion | viscous | long pot life**

WEICON Easy-Mix N 50 is a special two-component epoxy adhesive for manufacturing processes. Thanks to its long pot life, the adhesive is highly suitable for production processes with time-delayed assembly and positioning sequences.

N 50 is impact-resistant, shock-resistant, self-levelling, viscous and has a high tensile strength after curing.

The adhesive can be used on numerous materials such as metal, plastic, fibre composites, ceramics, glass, stone or wood.

The Dispenser Easy-Mix D 50 or the Manual Dispenser are required for processing Easy-Mix products in 50 ml containers.

## Characteristics

Base	Epoxy
Filler	unfilled
Texture	liquid
Colour	pale yellow, clear
Minimum shelf life	at room temperature 18 mon.

## Processing

Processing temperature	+15 °C to +40 °C
Component temperature	>3°C above dew point
Cure temperature	+6 °C to +40 °C
Relative air humidity	max. 85%
Mixing ratio by volume	1:1
Viscosity of the mixture	at +20 °C 5.000 mPa·s
Density of the mixture	1,1 g/cm <sup>3</sup>
Gap bridging up to max.	2 mm

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## Curing

Pot life	at 20 °C, 10 g batch	35 min.
Handling strength	(35 % strength)	3 h
Working strength after	(80 % strength)	15 h
Final strength	(100 % strength)	48 h
Shrinkage		0,08 %

## Mechanical properties after curing

- Measured after curing at		24 h RT + 24 h 60 °C
Tensile strength	DIN EN ISO 527-2	51 N/mm <sup>2</sup>
Elongation at break (tensile)	DIN EN ISO 527-2	3,6 %
E-modulus (tensile)	DIN EN ISO 527-2	1.900 - 2.200 MPa
Compressive strength	DIN EN ISO 604	80 MPa
Bending strength	DIN EN ISO 178	50 MPa
Hardness (Shore D)	DIN ISO 7619	81 ±3
Lap shear strength material thickn. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		22 N/mm <sup>2</sup>
Stainless steel V2A sandblasted		31 N/mm <sup>2</sup>
Aluminium sandblasted		14 N/mm <sup>2</sup>
Galvanized steel		22 N/mm <sup>2</sup>
PVC-rigid roughened		11 N/mm <sup>2</sup>

## Thermal parameters

Temperature resistance		-50 °C to +150 °C (-58 °F to +302 °F)
Tg after curing at room temperature	(DSC)	48,6 °C
Tg after tempering (at 120°C)	(DSC)	49,8 °C
Temperature conductivity		0,133 mm <sup>2</sup> /s

## Electrical parameters

Resistance	DIN EN 62631-3-1	1,32·10 <sup>-13</sup> Ω·m
Dielectric strength	DIN EN 60243-1 (20°C)	>26 kV/mm
Magnetic		no

## Approvals / Guidelines

IMPA Code	812981
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## Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

## Surface Pre-Treatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner).

## Application

WEICON Easy-Mix products can be processed straight from the double cartridge by means of the included static mixer. Dismiss the first 5 cm of the adhesive bead. The adhesive is applied to just one side. The specified pot life refers to a material batch of 10 ml at room temperature. Larger batch quantities will result in faster curing. Higher temperatures also reduce the pot life and curing time. (General rule: every increase by +10 °C above room temperature results in a decrease of the pot life and curing time by half). Temperatures below +16 °C increase the pot life and curing time significantly. From approx. +5 °C and below, no reaction takes place.

# Easy-Mix N 50

## Storage

WEICON epoxy adhesives should be stored in a dry place at room temperature. Unopened containers can be stored at temperatures from +18 °C to +25 °C. Protect from direct sunlight. Failure to observe these storage instructions will reduce the shelf life to 6 months. Epoxy resins generally tend to crystallise at temperatures below +5 °C. This effect is increased by large temperature fluctuations, e.g. during transport especially in the winter months. This has a negative impact on processing, curing and technical data, can, however, be reversed by heating the product (up to max. +50 °C, no open flame). In WEICON epoxy adhesives, crystallisation is reduced by the careful choice and combination of base resins (bisphenol A and F).

## Scope of delivery

Adhesive | Quadro Mixing Nozzle A

## Accessories

10005237	Dispenser Easy-Mix D 50, 1 PCE
10101999	WEICON Manual Dispenser, 1 x 1:1   2:1
10005236	Quadro Mixing Nozzle A, 1 PCE, blue
10026925	Helix Mixing Nozzle A, 1 PCE, white
10068261	Dosing Tip A Size 0,5 mm, 1 PCE

## Conversion table

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$	$\text{Nm} \times 8.851 = \text{lb}\cdot\text{in}$
$\text{mm}/25.4 = \text{inch}$	$\text{Nm} \times 0.738 = \text{lb}\cdot\text{ft}$
$\mu\text{m}/25.4 = \text{mil}$	$\text{Nm} \times 141.62 = \text{oz}\cdot\text{in}$
$\text{N} \times 0.225 = \text{lb}$	$\text{mPa}\cdot\text{s} = \text{cP}$
$\text{N}/\text{mm}^2 \times 145 = \text{psi}$	$\text{N}/\text{cm} \times 0.571 = \text{lb}/\text{in}$
$\text{MPa} \times 145 = \text{psi}$	$\text{kV}/\text{mm} \times 25.4 = \text{V}/\text{mil}$

## Available sizes

10005231	Easy-Mix N 50, 50 ml, pale yellow, clear
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To the product detail page:



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## Chemical resistance after curing\* (Excerpt)

1,4-Dioxane	-	Uric acid	-
Exhaust fumes	+	Impregnating oils	+
Adipic acid	-	Iodides (K, Na etc.)	-
aliphatic hydrocarbons	+	Potassium carbonate	+
Formic acid >10 % (methanoic acid)	-	Potassium hydroxide 0-20 % (caustic potash)	+
Ammonia anhydrous 25%	-	Milk of lime	+
Aniline	-	Cresol	-
aromatic hydrocarbons	+	Magnesium hydroxide	+
Barium hydroxide	+	Maleic acid (cis-ethylenedicarboxylic acid)	-
Benzoic acid	-	Methanol (methyl alcohol) <85 %	o
Benzyl alcohol	-	Methylene chloride	-
Benzyl chloride	-	Mineral oil	+
Boric acid	-	Naphthalene	+
Bromides	-	Sodium bicarbonate (sodium hydrogen carbonate)	+
Butadiene (1,3-)	-	Sodium carbonate (soda)	+
Butyric acid	-	Sodium chloride (table salt)	+
Butyl alcohol	o	Nitrates	-
Calcium hydroxide (slaked lime)	+	Nitrobenzene	-
Chloroanilines	-	Oils, vegetable and animal	+
Chloroform (trichlormethane)	-	Oxalic acid <25 % (ethanedioic acid)	o
Chlorosulphuric acid (wet and dry)	-	Perchloraethylene	-
Chlorosilanes	-	Kerosene	+
Chlorinated water (swimming pool concentration)	-	Phenol	-
Chromates (K, Na, etc.)	-	Phosphoric acid <50%	+
Chromic acid	-	Phthalic acid, phthalic anhydride	-
Cyanides (K, Na etc.)	-	Nitric acid <5%	-
Cyclohexanone	-	Sulphur dioxide (wet and dry)	-
Diethyl ether	+	Carbon disulphide	-
Mineral oil and mineral oil products	+	Sulphuric acid <5%	+
Acetic acid diluted <5%	o	Soap solution	+
Ethanol <85 % (ethyl alcohol)	o	Turpentine	+
Greases, oils and waxes	+	Carbon tetrachloride (tetrachloromethane)	-
Hydrofluoric acid	-	Tetralin (tetrahydronaphthalene)	-
Tannic acid diluted <7%	o	Trichloraethylene	-
Glycerin (trihydroxipropane)	+	Hydrogen peroxide <30 % (hydrogen superoxide)	o
Glycol	+		

+ = resistant 0 = for a limited time - = not resistant \*The storage of all WEICON Plastic Metal types was carried out at +20°C chemical temperature.

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